

Work Order ID 77379

77379

Page 1

December-06-11 1:15:25 PM

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Tube Assembly

Stop *NS2*

Start Date: 06/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/06 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3391

I

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 Rev: H & Dwg D3391 Rev: I

scribe batch # on fwd end at 90 degree

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

111

QC8- Inspect parts - second check

0.00

111

QC

Memo

0.00

Quality Control

INSPECT INSIDE BORE

1 Ø
M.M.L 11/12/06

1 Ø
M.M.L 11/12/06

11/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77379

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 06/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 13/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	HAAS CNC VERTICAL MACHINING #1	0.00				1	1		
120									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>I</u> <i>enl 11/12/11</i>								
	2-Deburr								
130	QC2- Inspect parts off machine FAI/FAIB	0.00				1	1		
130									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00				1	1		
140									
QC	Memo	0.00							
Quality Control	***INSPECT INSIDE BORE***								

W/O:		WORK ORDER CHANGES					
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Start Date: 06/12/2011 Start Qty: 1.00

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Cust Item ID:

Required Date: 13/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes					1		SAD	12-01-02
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES					1		SAD	12-01-02
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
170	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

DP 12-1-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 06/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 13/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
180									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .								
	*****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								

Handwritten notes: 12-01-03, 11-01-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 06/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 13/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

5/12/01/04

1 SAO 12-01-05

ET A 12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Accept

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 06/12/2011 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 13/12/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

220

Skidtubes

0.00

Skidtubes

Memo

Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: 117608
exp. date : 12-08
cure time 12hrs as per QSI0015

230

0.00

230

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

235

0.00

235

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

Hand Finishing

AND REALODINE AS PER PAR09-043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 77379

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 06/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 13/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240 Powdercoat Powder Coating	Memo START TIME: <u>2:15</u> OVEN TEMPERATURE: <u>3200F</u> FINISH TIME: <u>2:45</u>	0.00							<u>1X0 M-1 12/01/10</u>
250	QC3- Inspect Part Finish	0.00							
250 QC Quality Control	Memo	0.00							<u>1 0 11 12/01/11</u>
260	HandFinishing	0.00							
260 HandFinish Hand Finishing	Memo 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 <u>11 119509</u> Sikaflex expiry date: <u>12/01</u> 3- INSTALL WEARPLATES AS PER DWG	0.00							<u>1 0 11 12/01/11</u>

W119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77379

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 06/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 13/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 *270* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		12/01/12		(X)			
280 *280* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/O</u> Memo	0.00 0.00		0412-742-043/B75905			1	0	12/01/12
290 *290* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/1/18

12-01-18
(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

December-06-11 1:15:29 PM

77379

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 06/12/2011

Required Date: 13/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:	IPP Rev B	06-02-07	ECN773 dwg rev. D	EC	
	IPP Rev:C	06-03-28	Update Manuf. Instructions	JLM	
	IPP rev D	07.03.20	revF dwg	EC	
	IPP rev E	07.11.07	rev G dwg ecn 1053p	EC	verified by: DD
	IPP Rev:F	07-11-13	ECN 1056	DD	verified by: EC
	IPP Rev:G	08-09-10	revH as per dwg	DD	verified by:EC
	11.11.14 AS PER REV.I	DD	verified by:JLM		IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	1.0000	1	1			
D4095-047 Wearpad Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		1							
				76208		1							
D4095-049		Manufactured	No			260	Each	3.0000	1	1			
D4095-049 Wearpad Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		3							
				76217		3							
D6014-090		Manufactured	No			100	Each	12.0000	1	1			
D6014-090 ALUMINUM EXTRUSION													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		12							
				66179		12							

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 77379

77379

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 06/12/2011

Required Date: 13/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

63.0000

4

4

D3670-4-200

SPACER

**

21 # 12-01-06

Location

Loc Qty

Loc Code

LG001

63

72851

63

D2646

Manufactured No

270

Each

207.0000

1

1

D2646

Aft Cap

**

21 12/01/11

Location

Loc Qty

Loc Code

FP002

190

73294

2

73825

188

FP004

8

68280

5

70945

1

71070

2

FP005

4

71038

4

FP006

5

62678

5

D3672-1

Manufactured No

270

Each

1,178.000

2

2

D3672-1

Phenolic Washer

**

21 12/01/11

Location

Loc Qty

Loc Code

FP

414

66821

414

ST074

764

72229

264

76277

500

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 06/12/2011

Required Date: 13/12/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

2,176.000

14

14

AI S4-1032-130

Insert

**

ml 12/01/11

Location

Loc Qty

Loc Code

ST280

1976

119084

1976

x14

ST281

200

119632

200

ALS4-1032-225

Purchased

No

270

Each

1,724.000

AI S4-1032-225

Insert

**

8/12 ml 12/01/11

PTO

Location

Loc Qty

Loc Code

ST281

1724

108696

199

110768

62

118386

858

x12

118966

605

AN3C4A

Purchased

No

270

Each

2,382.000

6

6

AN3C4A

BOLT

**

ml 12/01/11

Location

Loc Qty

Loc Code

ST350

2382

117313

2

117688

5

117872

10

118112

16

118451

2

118838

826

119328

521

119749

1000

y6

W/O: 77379		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3391-025 PAR #: _____ Fault Category: Finishing NCR: Yes No DQA: [Signature] Date: 12/1/23
12-1129 Resolution: Rework Disposition: Rework QA: N/C Closed: [Signature] Date: 12/1/23

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.01.18	260	INSTALLING 12 INSERTS IN LIEU OF 8. RC: TOOLING NOT UPDATED, EXTRA HOLES DRILLED.	↓ 12.01.18 GSI 042	ACCEPTABLE TO INSTALL GTZ.(4) EXTRA ALS4-1032-225 REF SHT. 8. PLUG BOLT Hole w/ SIKAFLOX	[Signature] 12-01-18 K	[Signature] 12/6/18	↓ 12.01.18 GSI 042	[Signature] 12/6/18

NOTE: Date & initial all entries

Picklist Print

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 06/12/2011

Required Date: 13/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

1,278.000

4

4

AN3C5A

Bolt

**

Handwritten: 12/06/11

Location

Loc Qty

Loc Code

FP

7

115835

7

ST350

1271

116419

28

117343

17

117764

49

117872

2

118451

175

119127

500

119749

500

Handwritten: XJ

AN960C10L

NAS1149C0332

Purchased

No

270

Each

0.0000

10

10

***AN960C10L ***

washer

**

Handwritten: (X10) M119736 12/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 77379
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

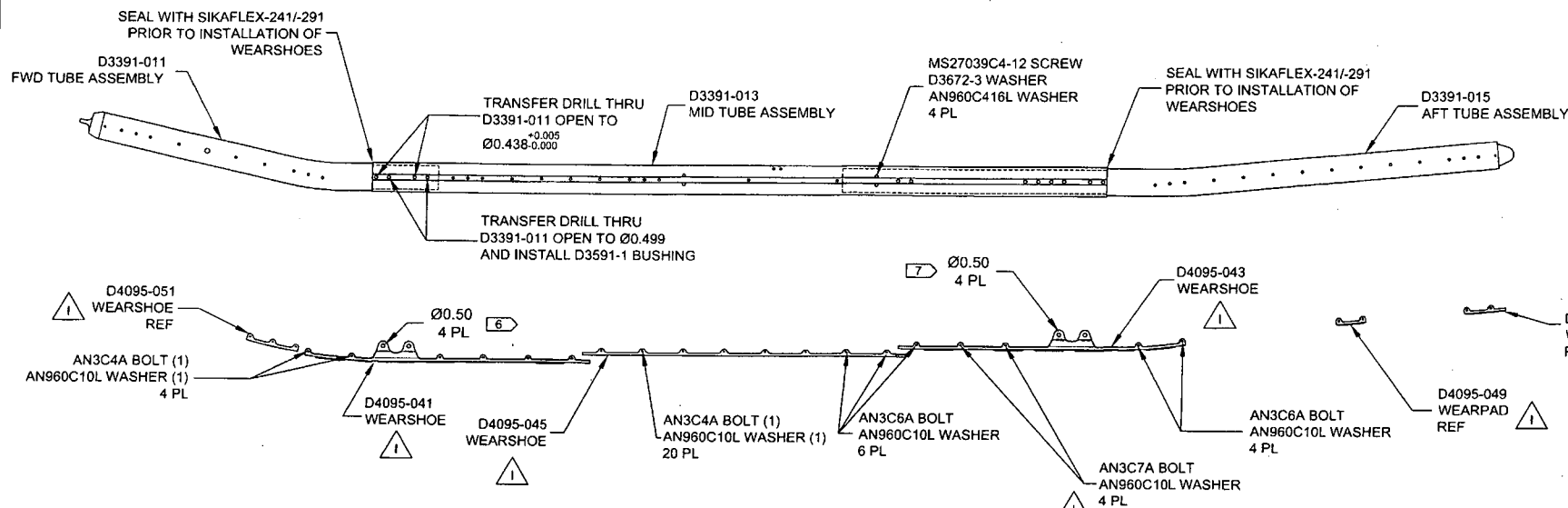
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	mm. L-02
3.500	+/-0.010	3.498	✓		vern	lwc-08
88.93	+/-0.030	88.920	✓		tape	mm. L-02
Ø3.200	+/-0.010	3.200	✓		vern	lwc-08
88.93	+/-0.030	88.920	✓		tape	mm. L-02
Ø3.750	+/-0.010	3.750	✓		vern	lwc-08
30° x 160° chamfer	+/-0.010	30° x 160	✓		CI	

Measured by: gmm. L	Date: 11/12/07
Audited by: [Signature]	Date: 11/12/11

HAAS Section						
1.526	+0.000/-0.030	1.510	✓		Vern HL-D6	
7.500	+/-0.010	7.500	✓		"	
27.750	+/-0.010	27.750	✓		M-type HL-D6	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.296	✓		Vern HL-D6	
0.200	+/-0.010	.205	✓		"	
3.520	+/-0.010	3.524	✓		"	
0.687	+0.010/-0.000	.688	✓		"	
R0.062	+/-0.010	R.062	✓		R-6	
Ø0.484	+0.005/-0.001	Ø.488	✓		Vern HL-D6	

Measured by: [Signature]	Date: 11/12/11
Audited by: B.A.	Date: 11/12/13

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	



SHOP COPY D3391-041 ASSEMBLY

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WITHOUT NOTICE
WORK ORDER

NO. 77379 M.C.J.

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

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I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.		D3391	SHEET 1 OF 8
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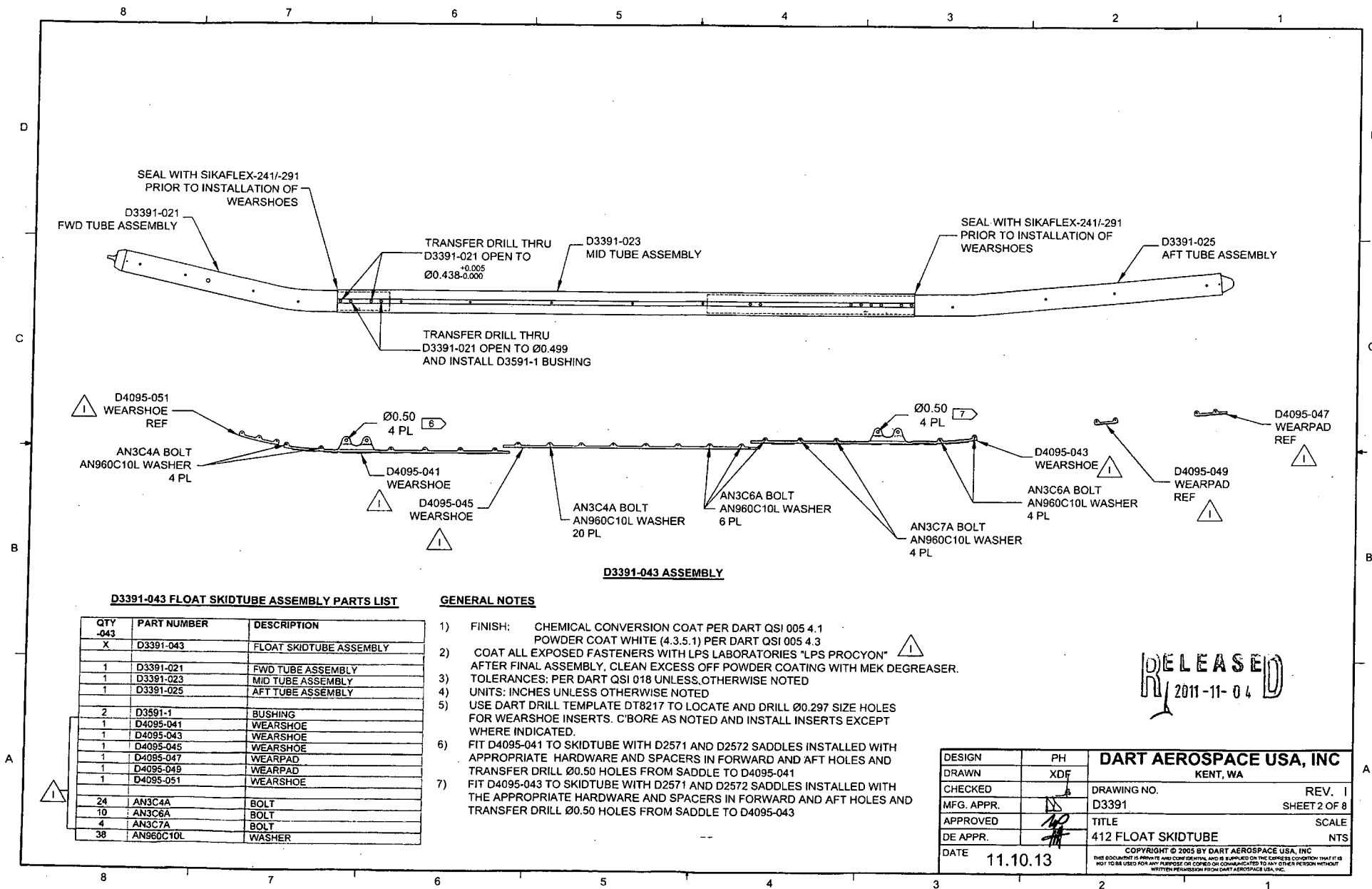
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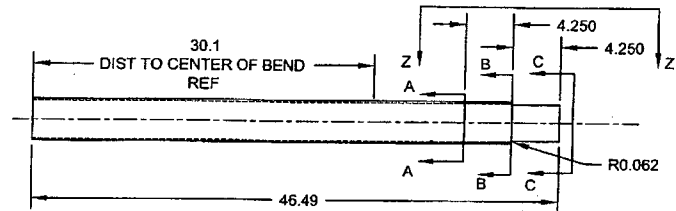
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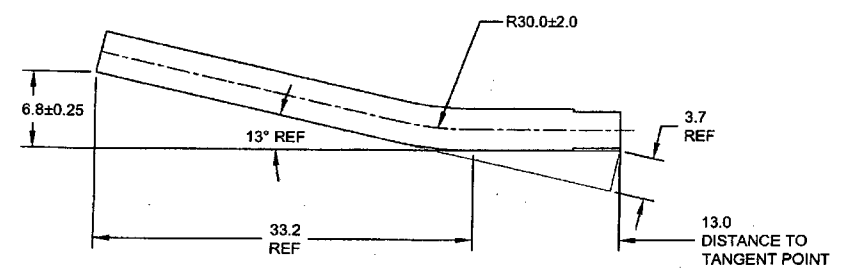
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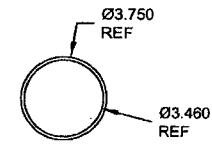
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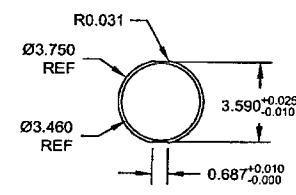
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



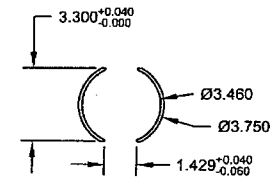
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



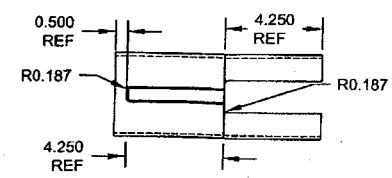
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
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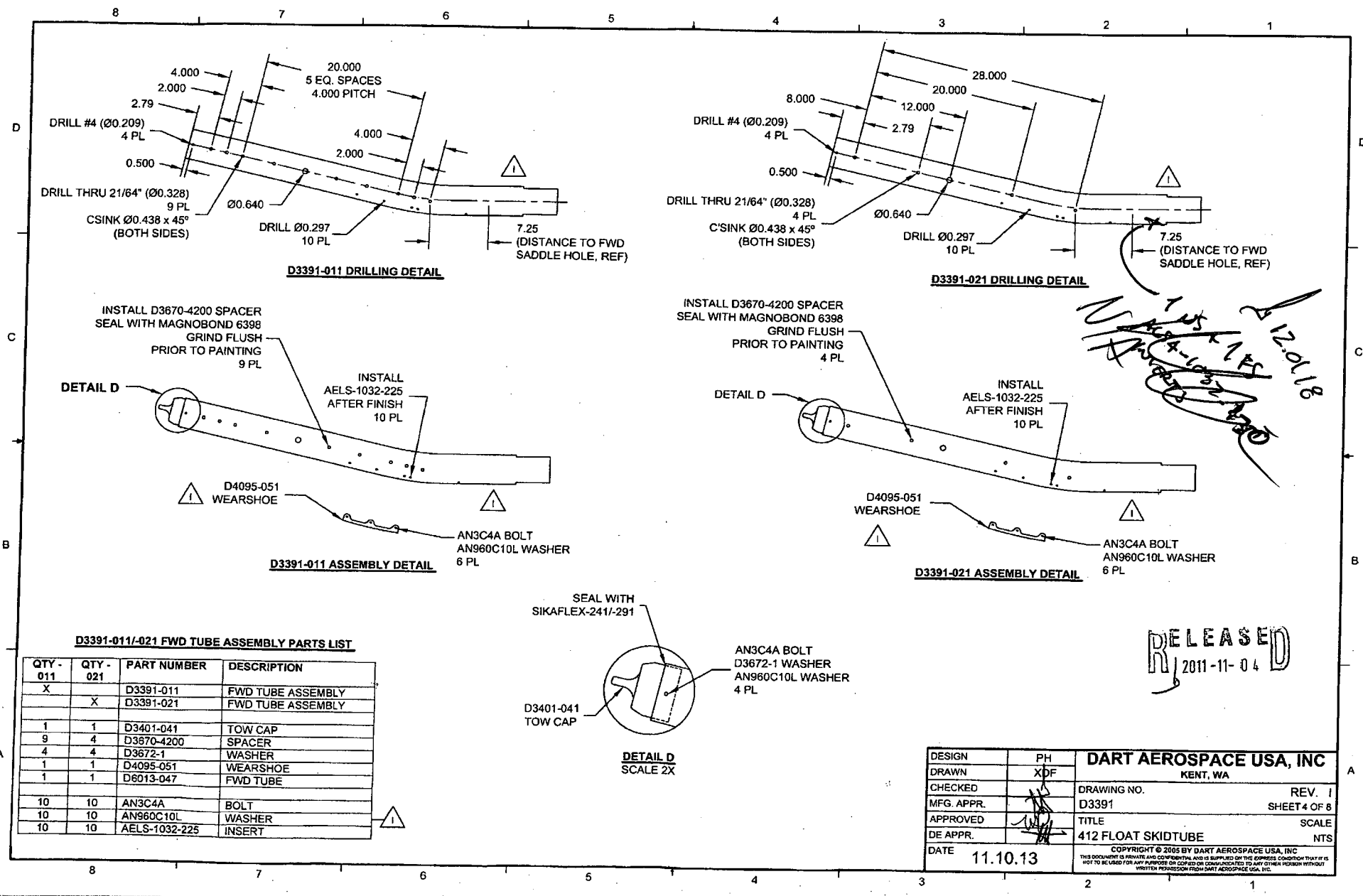
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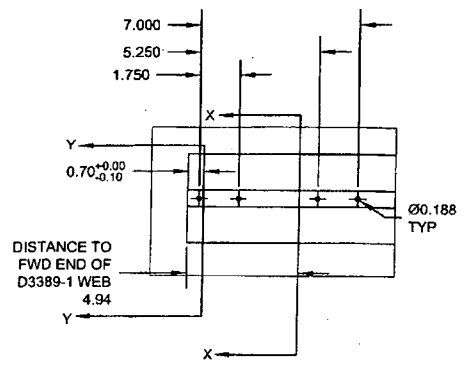
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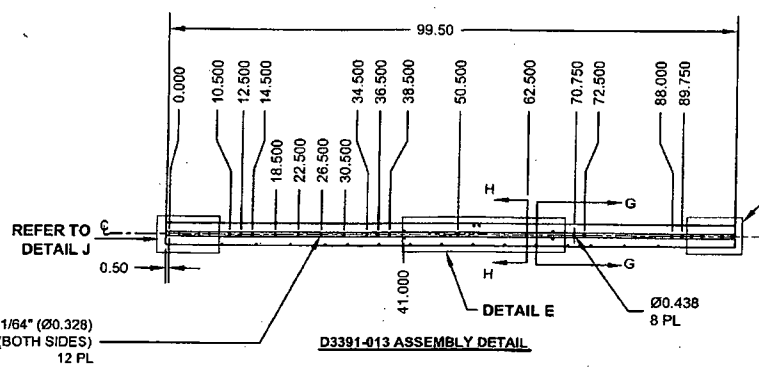
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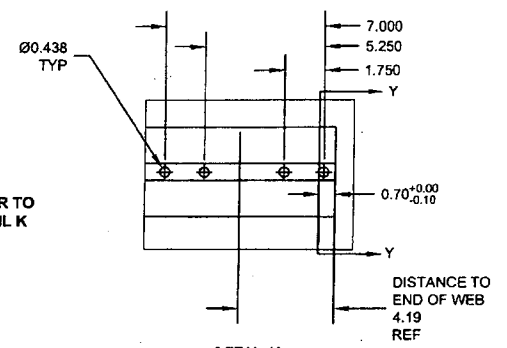
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DETAIL J
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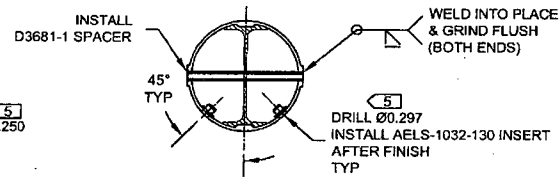
D3391-013 ASSEMBLY DETAIL



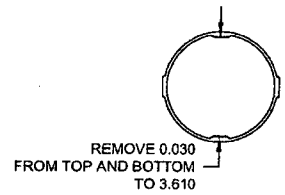
DETAIL K
SCALE 4X



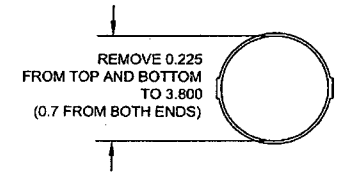
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



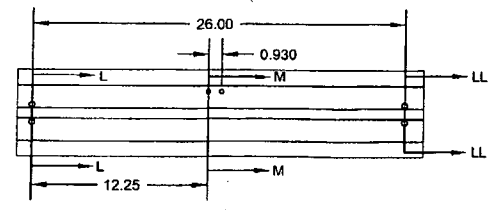
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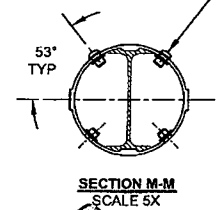
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

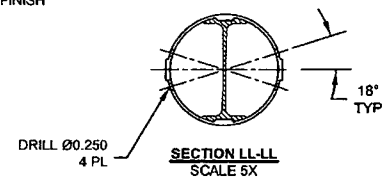
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



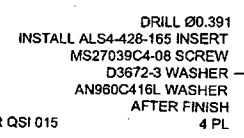
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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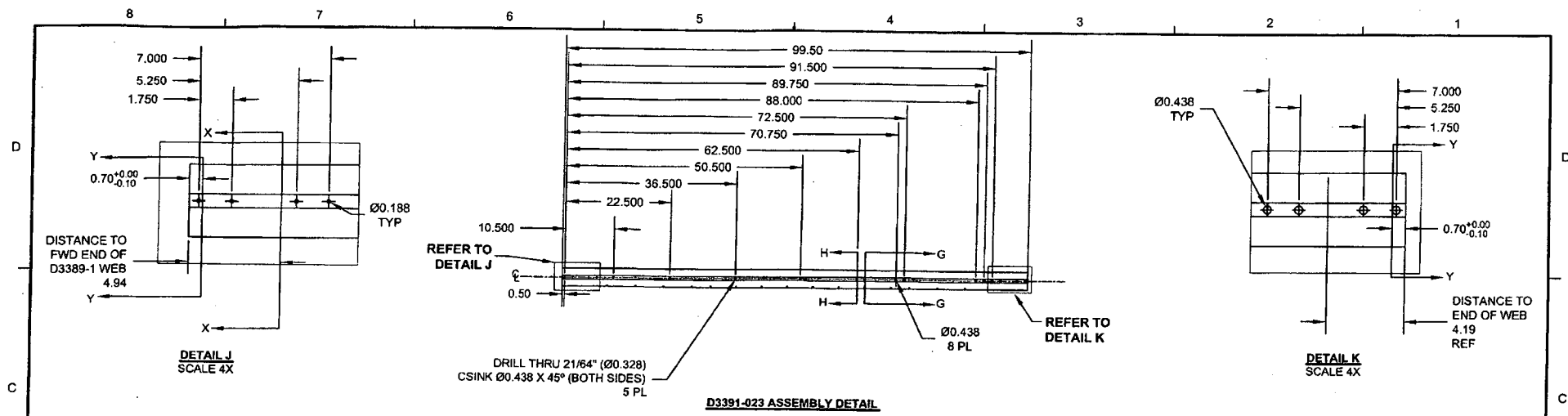
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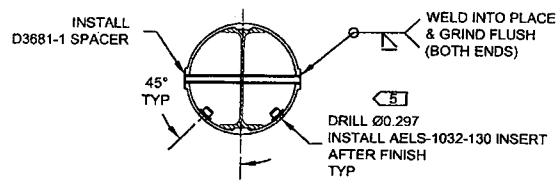
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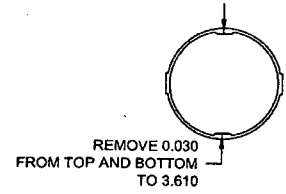
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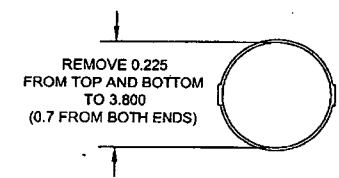
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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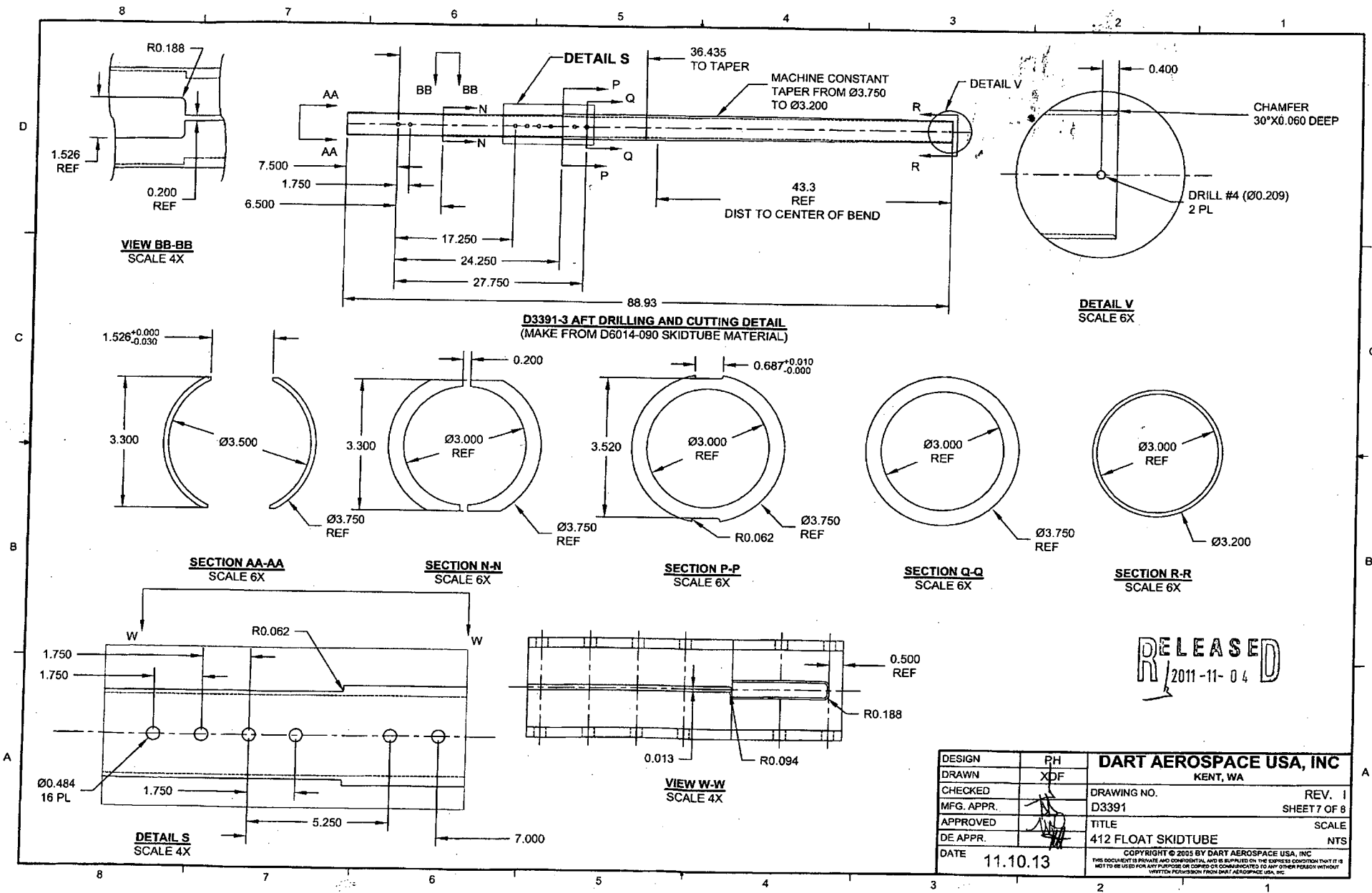
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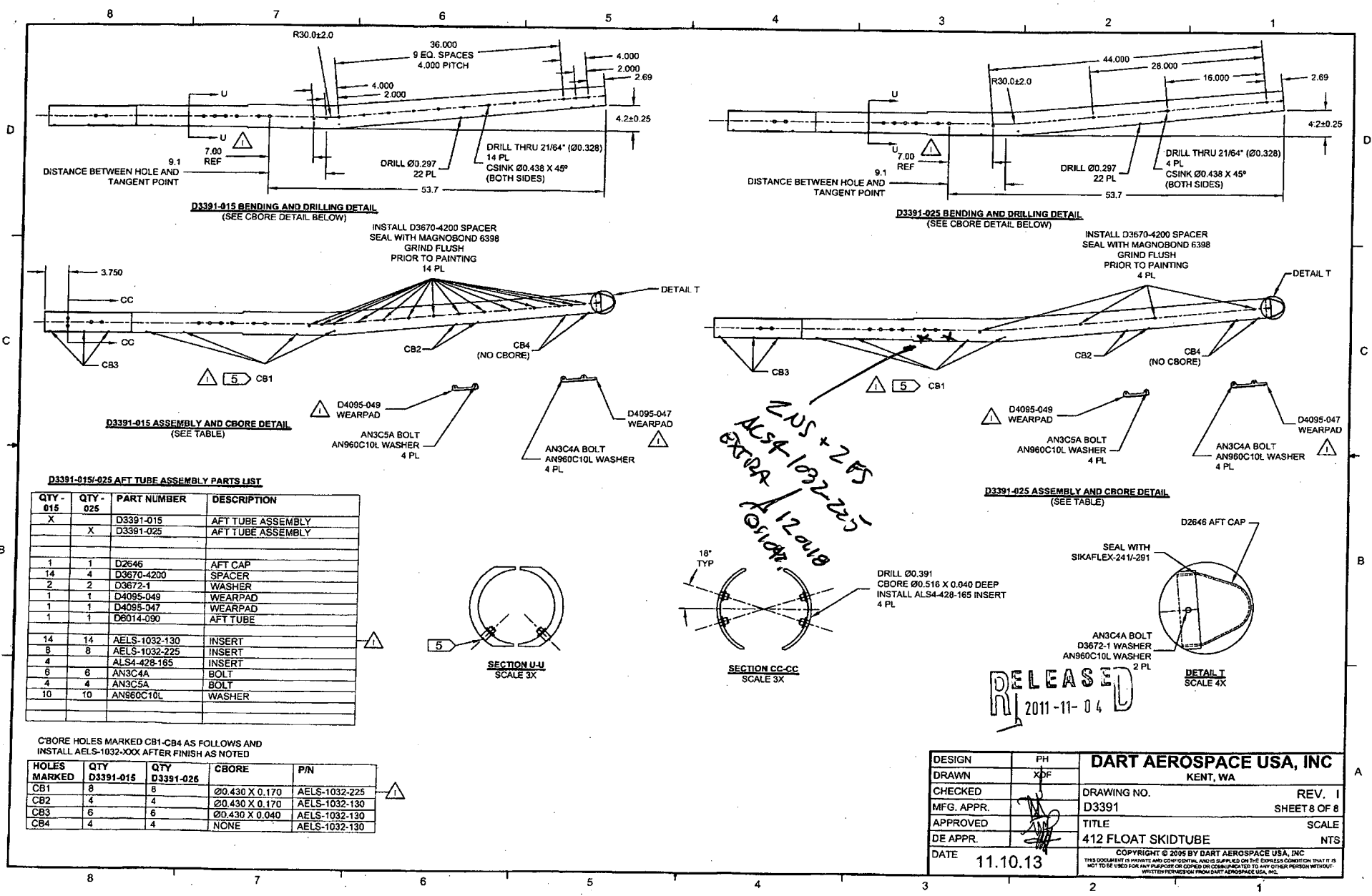
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